

Page 1

JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Work Order ID 132376

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132376

Page 2

Item ID: D350-616-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Deck Plate

Stop ***NS2***

Start Date: 4/29/15 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-616-015

Location: _____

PPP Rev: _____

*packed onto B 132447**3* *CA 150708*
Ref

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ *JUL 08 2015**MCJ* *JUL 08 2015*

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Picklist Print

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Page 1

Work Order ID: 132376

132376

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 4/29/15

Required Date: 5/07/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:C Removed Manufacturing 05-12-05 JLM
 IPP Rev:D Add D3494-1 05-12-05 JLM
 IPP rev E added parts per NCR 08-041 08.04.30 EC verified by: DD
 IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP REV:G
 13.04.03 PER IIN REV.F DD VERF:JLM IPP REV:H 13.05.21
 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4778-1 *D4778-1* Stub Cover		Manufactured	No				Each	15.0000		3			
	DAS 02 9-89			<u>Location</u> ST224B 117485 128975				<u>Loc Qty</u> 15 2 13					<u>Loc Code</u> DAS 27 9-89
D4779-041 *D4779-041* Aft Cover Mounting Bracket Assembly		Manufactured	No		B132781		Each	8.0000		3		J.A	
	DAS 02 9-89			<u>Location</u> ST127 128982				<u>Loc Qty</u> 8 8					<u>Loc Code</u> DAS 27 9-89
D4780-041 *D4780-041* Fwd Cover Mounting Bracket Assembly		Manufactured	No		B132795		Each	6.0000		3		J.A	
	DAS 02 9-89			<u>Location</u> ST127 128893				<u>Loc Qty</u> 6 6					<u>Loc Code</u> DAS 27 9-89
				B132612						3		J.A	JUL 07 2015

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

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Work Order ID: 132376

132376

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 4/29/15

Required Date: 5/07/15

Start Qty: 3.00

Required Qty: 3.00

MS35207-263

Purchased No

Each 173.0000 8 24

MS35207-263

Screw

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST276

173

104746

173

24 JA

D2344

Manufactured No

110 Each

15.0000 1 3

D2344

Deck Plate Aft

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST225A

15

114962

9

3 JA

130887

6

D2348

Manufactured No

110 Each

47.0000 4 12

D2348

Wearplate (Key Way)

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST012a

47

128818

47

10 2 3 JA

D2353

Manufactured No

110 Each

25.0000 1

D2353

Stiffener

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST224B

25

20290

25

3 JA JUL 07 2015

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Work Order ID: 132376

132376

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 4/29/15

Required Date: 5/07/15

Start Qty: 3.00

Required Qty: 3.00

D2364

Manufactured No

110

Each

11.0000

1

3

D2364

Deck Plate Fwd

DAS
02
9-89

Location

Loc Qty

Loc Code

ST225A

11

120134

2

128803

7

130853

2

**

DAS
27
9-89

3 J.A

D2365

Manufactured No

110

Each

28.0000

2

6

D2365

Wearplate Pip Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

ST006

28

120093

4

128788

24

**

DAS
27
9-89

6 J.A

D2369-1

Manufactured No

110

Each

10.0000

1

3

D2369-1

Locator Plate

DAS
02
9-89

Location

Loc Qty

Loc Code

st225b

10

128840

8

130917

2

133416

**

DAS
27
9-89

2
4
3 J.A

D2369-3

Manufactured No

110

Each

12.0000

1

3

D2369-3

Locator Plate

DAS
02
9-89

Location

Loc Qty

Loc Code

st225b

12

128987

10

131159

2

**

DAS
27
9-89

3 J.A

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Work Order ID: 132376

Parent Item: D350-616-015

Parent Item Name: Deck Plate

132376

D350-616-015

Start Date: 4/29/15

Required Date: 5/07/15

Start Qty: 3.00

Required Qty: 3.00

MS20426AD4-5

Purchased

No

110

Each

715.0000

25

75

MS20426AD4-5

RIVET

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

691

m130922

691

ST312

24

m125807

24

75

JA

MS20426AD4-6

Purchased

No

110

Each

932.0000

25

75

MS20426AD4-6

Rivet

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

446

M128812

446

MF4

177

124392

177

ST312

309

124392

83

M128812

226

7

J.A

MS20426AD5-7

Purchased

No

110

Each

134.0000

6

68 18

MS20426AD5-7

RIVET

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST312

134

101340

134

18

J.A

MS20426AD5-8

Purchased

No

110

Each

359.0000

6

18

MS20426AD5-8

RIVET

9-89
27
DAS

DAS
02
9-89

Location

Loc Qty

Loc Code

ST312

359

4533

359

18

J.A

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OTHER : _____																																																																					

Picklist Print

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Page 5

Work Order ID: 132376

132376

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 4/29/15

Required Date: 5/07/15

Start Qty: 3.00

Required Qty: 3.00

MS20601-AD4W2

Purchased

No

110

Each

170.0000

15

45

MS20601-AD4W2

Rivet

DAS

27

9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST308

161

121255

1

m131467

160

WA003

9

m126975

9

45 J.A

MS20601-AD4W3

Purchased

No

110

Each

68.0000

30

90

MS20601-AD4W3

Rivet

DAS

27

9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

CCK004

50

m131618

50

ST308

18

114538

18

90 J.A

MS21042L3

Purchased

No

110

Each

1,135.000

6

18

MS21042L3

Nut

DAS

27

9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

602

M131317

602

ST305

113

116549

12

126333

49

M128754

2

M131624

50

M132382

18 J.A

JUL 07 2015

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

May-07-15 2:34:57 PM

Page 6

Work Order ID: 132376

132376

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 4/29/15

Required Date: 5/07/15

Start Qty: 3.00

Required Qty: 3.00

MS24693-C273

Purchased

No

110

Each

40.0000

6

18

MS24693-C273

SCREW

DAS
02
9-89



Location

Loc Qty

Loc Code

ST291

40

m128401

2

m131618

38

132262 x15

Each

273.0000

22

3
15
60

J.A

**

DAS
27
9-89

MS24693-C48

Purchased

No

132262 x15

Each

273.0000

22

3
15
60

J.A

**

DAS
27
9-89

MS24693-C48

SCREW

DAS
02
9-89

Location

Loc Qty

Loc Code

ST291

4

m128818

4

ST299

269

131677

269

110

Each

1,661.000

14

66
42

J.A

**

DAS
27
9-89

NAS1149D0363J

Purchased

No

131677

110

Each

1,661.000

14

66
42

J.A

**

DAS
27
9-89

NAS1149D0363.J

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

292

m128429

292

ST269

800

m126319

9

m131618

791

M132317

42

J.A

JUL 07 2015

May-07-15 2:34:57 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

DAS
Q2
9-59

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
[Signature]

BY: D. SHEPHERD (DE # 02)

DATE: 13.04.01
CERT. NO.: SH96-10
ISSUE NO.: 3

G	D4812-041 PATIENT STOP ASSY WAS D2493 (SH1), UPDATE WEIGHT AND BALANCE TABLE (SH2), NEW PART/FIGURE (SH7), REVISE FIGURE (SH 9), ADD OPTION APPLICABILITY NOTE (SH11)	DB	13.04.01
F	REPLACE MMS-D350-616 REF. WITH ICA-D350-616 INCORPORATE DSI 9645	DC	13.03.01
E	MAKE DSI 9310 STANDARD, D3179-041 REPLACES D2350	RF	08.11.07
D	ADD D3494-1 STUB COVER	MB	06.01.19
C	ADD DSI 9112/9117/9130/9236/9310	MB	06.01.10
B	ADD VIEW OF D2493 TO SHEET 9	BW	96.01.09
A	NEW ISSUE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	N/A	D350-616	SHEET 1 OF 13
APPROVED	W	TITLE	SCALE
DE APPR.	W	AS 350/355 LITTER KIT INSTALLATION	NTS
DATE	13.04.01	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	